

Work Order ID 53323-2

October 30, 2009 10:18:37 AM

Split



Page 1

Item ID: D412-666-011

Accept



Setup Start



Revision ID: C1

3

Stop



Item Name: Gross Weight Towing

Start Date: 30/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 07-10-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-666

Rev C1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP412-666-011

CHG 004

802/11/20

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

alula sl 34

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 802/11/20

(13) 4

Work Order ID 53323

October 30, 2009 10:18:37 AM



Page 2

Item ID: D412-666-011
Revision ID: C1
Item Name: Gross Weight Towing

Accept



Setup Start



Stop



Start Date: 30/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 4.00



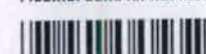
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-666-011 Location: _____ PPP Rev: 12

0.00

0.00

09/11/23 (B)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/11/25 mk

mk
09-11-23

Picklist Print

Page 1

October 30, 2009 10:18:41 AM

Work Order ID: 53323

Parent Item: D412-666-011RevC1

Parent Item Name: Gross Weight Towing

Comments:

Start Date: 30/10/2009

Required Date: 02/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6-15A



Bolt

Purchased

No

Each

72.0000

16.0000



9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

108744

12

111424

10

111425

50

Each

16.0000

16.0000



9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

110002

1

111425

15

Each

798.0000

32.0000



8x 3x15x SP

9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

798

112314

298

112828

500

32x SP

3x

AN6-45A



Bolt

Purchased

No

Each

16.0000

16.0000



9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

110002

1

111425

15

Each

798.0000

32.0000



8x 3x15x SP

9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

798

112314

298

112828

500

32x SP

3x

AN960JD616



Washer

Purchased

No

Each

798.0000

32.0000



8x 3x15x SP

9/11/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

798

112314

298

112828

500

32x SP

3x

Picklist Print

Page 2

October 30, 2009 10:18:41 AM

Work Order ID: 53323



Parent Item: D412-666-011RevC1



Parent Item Name: Gross Weight Towing

Start Date: 30/10/2009

Required Date: 02/11/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2888RevA2 		Manufactured	No				Each	8.0000	8.0000		9/10/2	(4x) SP

Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47335

8

8

Each

623.0000

16.0000

8x SD

9/10/2

(C/X) SP

MS21042L6



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

623

105077

22

110002

5

111548

8

111578

400

112492

188

16x SD

34

October 30, 2009 10:18:41 AM

Shop Packet Print

Page 2

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

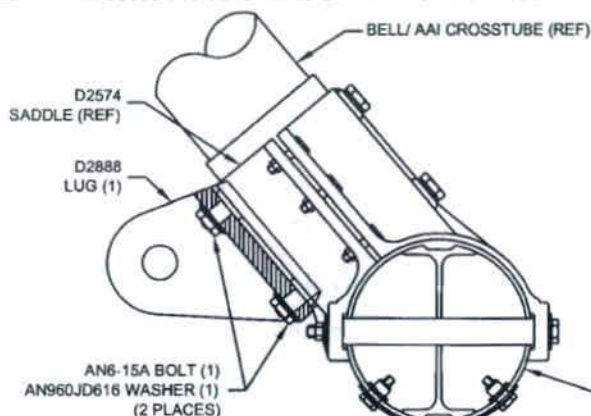


FIGURE 1
(BELL/AAI CROSSTUBES)

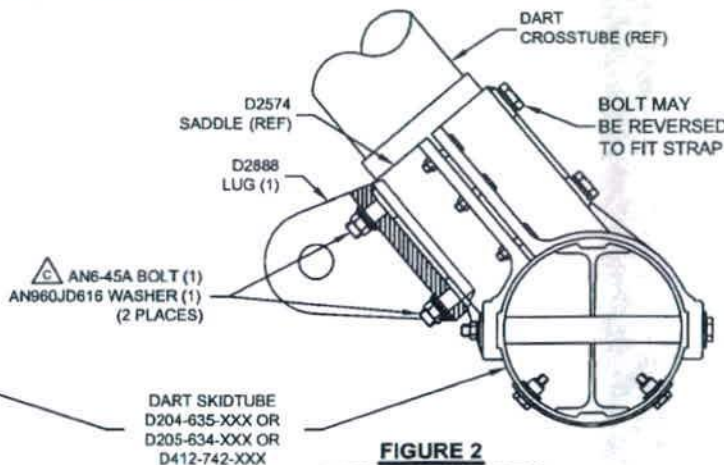


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 GROSS WEIGHT TOWING KIT	1:4
DATE	07.08.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

53323

